

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028454**Date Inspected:** 20-Sep-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job site**CWI Name:** N/A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QAI) Rodney Patterson was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Ultrasonic Testing OBG

This QA performed verification Ultrasonic Testing (UT) on Complete Joint Penetration (CJP) Deck panel drop-in web/flange connections for lift 13E. The weld was previously tested and accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QAI's findings are as follows;

Lift 13E Deck drop-in Flange splice (Weld No. 13E-PP123-W2.8-BF3)

The QAI performed a minimum of 100% verification of this weld. A total of one rejectable indication was observed at the time of inspection. The Rejectable indication was confirmed by ABF QC Steve Jensen during the shift. During the final visual inspection of this weld and after the review of the weld detail at this location, the QAI observed that the required 8mm reinforcing fillet weld was not present at the time of inspection. The ABF QC inspector Salvador Merino was notified and responded that the reinforcing fillet would be added during the repair of the rejected portion of the weld.

Lift 13E Deck drop-in web splice (Weld No. 13E-PP122-E2.5-BW1)

The QAI performed a minimum of 50% verification of this weld. No rejectable indications were observed at the time of inspection.

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Lift 13E Deck drop-in web splice (Weld No. 13E-PP122.5-E2.8-BW1)

The QAI performed verification of this weld in way of a repair at Y=520 previously rejected by the QAI on 07-26-2012. No rejectable indications were observed at the time of inspection.

Magnetic Particle Testing (OBG 13E)

This QA Inspector performed a minimum of 15% verification Magnetic Particle Testing (MT) of the lift 13E web and flange connections. This QA Inspector generated a TL-6028 MT report on this date. The results of the inspection are as follows;

Lift 13E Flange Tie bracket (Weld No. 13E-PP122-E2.1-BR1)

The QAI performed a minimum of 15% verification of this weld from face A/B. No rejectable indications were observed at the time of inspection.

Lift 13E Flange Tie bracket (Weld No. 13E-PP122.5-E2.1-BR1)

The QAI performed a minimum of 15% verification of this weld from face A/B. No rejectable indications were observed at the time of inspection.

Lift 13E Flange Tie bracket (Weld No. 13E-PP123-E2.1-BR1)

The QAI performed a minimum of 15% verification of this weld from face A/B. No rejectable indications were observed at the time of inspection.

Lift 13E Flange Tie bracket (Weld No. 13E-PP123.5-E2.1-BR1)

The QAI performed a minimum of 15% verification of this weld from face A/B. No rejectable indications were observed at the time of inspection.

Lift 13E Flange Tie bracket (Weld No. 13E-PP124-E2.2-BR1)

The QAI performed a minimum of 15% verification of this weld from face A/B. No rejectable indications were observed at the time of inspection.

Lift 13E Flange Tie bracket (Weld No. 13E-PP124.5-E2.2-BR1)

The QAI performed a minimum of 15% verification of this weld from face A/B. No rejectable indications were observed at the time of inspection.

Lift 13E Deck drop-in web splice (Weld No. 13E-PP122-E2.5-BW1)

The QAI performed a minimum of 15% verification of this weld from face A/B. No rejectable indications were observed at the time of inspection.

Lift 13E Deck drop-in web splice (Weld No. 13E-PP122.5-E2.8-BW1)

The QAI performed a minimum of 15% verification of this weld from face A/B. No rejectable indications were observed at the time of inspection.

The QAI spent a portion of this shift reviewing and documenting the status and completion of various production welding tracking logs for lift 13E-14E drop-in deck work currently in-process. The QA recorded the information on the OBG tracking log.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Patterson,Rodney	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
